

Date: Wednesday, 7/4/2007 3:57:53 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING	PROTOTYPE
Job Number : 33305		
Estimate Number : 12494		
P.O. Number : <i>N/A</i>	Part Number : D35147	
This Issue : 7/4/2007 S.O. No. : <i>N/A</i>	Drawing Number : UNDER REVIEW	
Prsht Rev. : NC	Project Number : <i>N/A</i>	
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : <i>N/A</i>	
Previous Run : 32537	Material : <i>N/A</i>	
Written By : <i>[Signature]</i>	Due Date : 7/11/2007	Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>		
Comment : Est Rev:A New Issue 06-07-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.2518 sf(s)/Unit Total : 0.2518 sf(s)
 6061-T6 .040 Sheet
 (M6061T6S040)
 Batch: *M 10332T 100742*

CERTIFICATE OF CONFORMITY
 REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3514
 Dwg Rev: *PROL*
 Prog Rev: *PROL*

Ensure Grain Direction is correct**

2-Deburr if necessary *H*

H

MF

07-07-09

(Pto)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 07-07-10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/07/10

5.0	BRAKE NC	NC BRAKE
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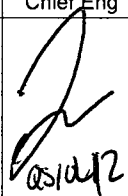

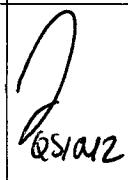
Comment: NC BRAKE
 Form Joggle as per Dwg D3514

SP 02/07/10

07/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-7 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>33305</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.07.09	2.0	1 Part SCRAP wrong mat. used 0.050" instead of 0.040" R.C. Human Error	 05/10/12	Scrap and Replace mat with correct mat. Remind Employee to be more cautious when pulling mat. BATCH # M 102723 M100742	03-9-10 	En 07/07/10	 05/10/12	En 07/07/10

NOTE: Date & initial all entries

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Drawing Name: GPS RECEIVER HOUSING

Job Number: 33305

Part Number: D35147

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

FAI NEEDS MORE
DIMS
CB 07.07.11

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



07.07.16

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per Q91 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

FOR ENGINEERING USE ONLY

07.07.19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

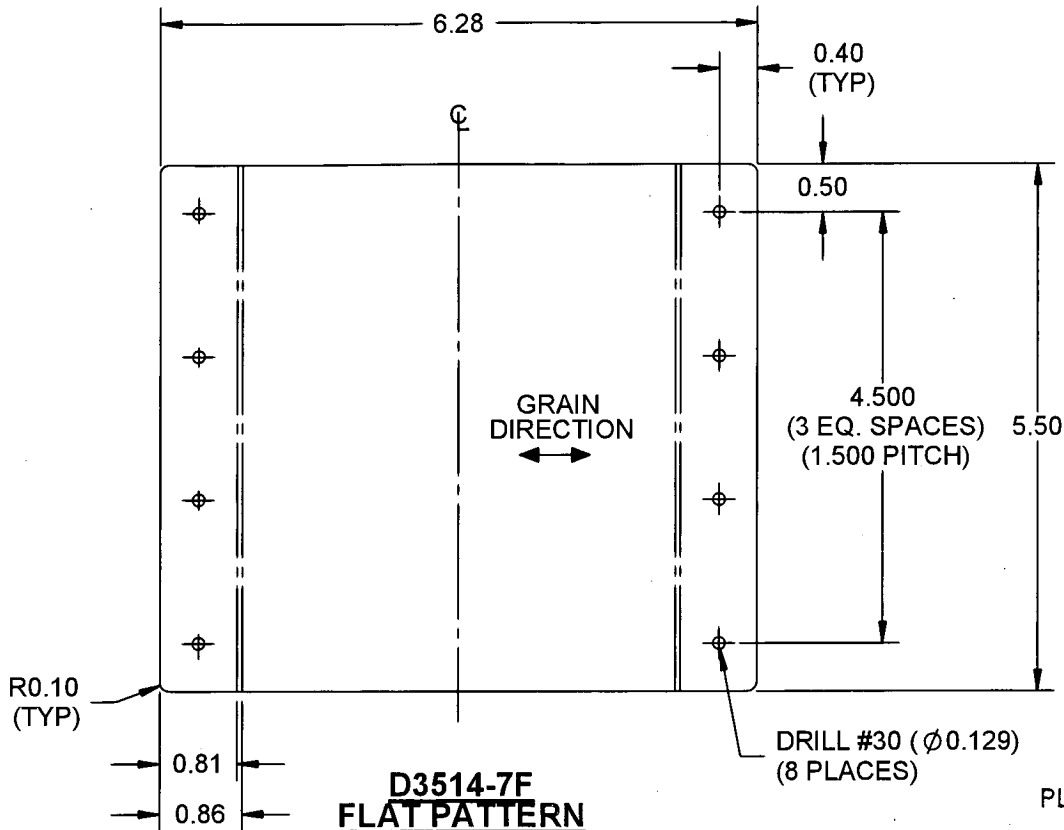
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07/07/18

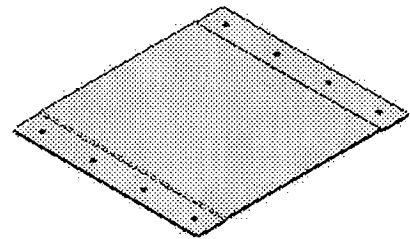
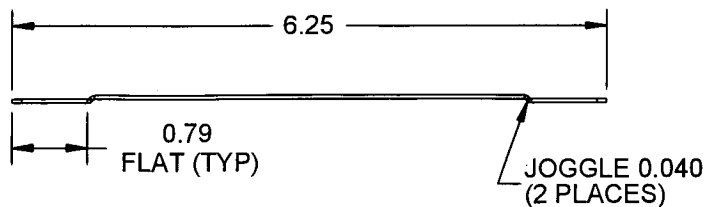
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3514	REV. A SHEET 8 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:2



Handwritten signature/initials

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

LE 07.06.22



D3514-7 BOX BOTTOM (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \bar{C}

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Receiving Report

Date: April 21/06
 Supplier: Copper & Brass

Batch No: 1100742
 Dart P/O: 1005

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☐
 Shipment Complete: Yes ☐ No ☒
 Q.C. Inspection ☐

Discrepancies						Comments
Part No	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	
M50524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0650		12	10	0	2	

ISR No _____

Initials of receiver (if shipment OK) [Signature]

Production/Admin

Date

Received/Costing

Initial

FORM 09000V Forms \ Purchase \ RECEIPT rev B

Accounting:

Date

AP/MR

Initial


DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
PLEASE REMIT IN CANADIAN FUNDS		GST/HST		9.66
TOTAL \$				147.73

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH. PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

ART AEROSPACE	SHIP DATE 04/24/06 SHP	GROSS WEIGHT	QUOTE 30-161074-1	0 OF 10 PACKING LIST	
			ORDER DATE 04/13/06 ORD	TEST RESULTS	
ART AEROSPACE	WORK ORDER **		DELIVERY DATE 04/24/06 DEL	SHIP BRANCH 30(04)	SELL BRANCH 30-TOR
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA K6A 1K7			WORK ORDER UZ3809		
			6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y		
			Copper and Brass Sales Canada  A ThyssenKrupp Materials NA company ThyssenKrupp		
ORDER PO NUMBER 000001005	TERRITORY 01	ENTRY ID 30BXT	CUSTOMER SIGNATURE:		DATE:
INSIDE SALES LINDA LACELLE	INSIDE SALES TELEPHONE (905) 632-9577		QUANTITY	ORDERED	SHIPPED
SHIP VIA			INVENTORY	54.19 LB	52.00
SHIPPING STATUS			BILLING	2.00 PC	2.00
COMPLETE X			WAREHOUSE		
PARTIAL			PACKED WITH OTHER GOODS UZ3800		
CANCEL			FINISHED GOODS LOCATION WARN LABEL:1001		
CUSTOMER COMMON/FRT-CCX			PREMIUM STATUS PPD		

PART DESCRIPTION 063496-4

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 ART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 dimensions., Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

Rec'd 4/21

SPECIAL INSTRUCTIONS			
Shipping, do not place any packages or goods on top of our material."			
SCRAP	FILLED BY SC	PACKED BY	Q/A AUDIT
MAX SKID WEIGHT 100	LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK		MAXIMUM BUNDLE WEIGHT 200
PKGS	SKIDS	BOLS	TUBES
CNS	FLAT	COILS	
INSPECTION RECORD			

TEST RESULTS

DECLARATION OF COMPLIANCE
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 Our products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 1-800-249-2333-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027	ASTM-B209	ROHS COMPLIANT
QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS TAG NO
52.00 LB CORUS	0CC1837 7124901	